



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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RBW6305G19731-3G
Job Sheet 194237



Part No: RBW6305G19731-3G

Job Qty: 1 pcs

Part Name: Main Rotor Drive Tool 2 (Box 2 Of 2)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/29/19

Job Tracking No:

Due Date: 5/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 15188*

Note: DWG RBW6305G19731-3G Rev A IPP Rev A 18.03.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/17/19		0.00	1.00	Small Fab - 1		DAS 71 9-89
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	5/17/19		0.00	1.00	Small Fab - 1 - B4B		DAS 71 9-89
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 4	1 pcs	5/17/19		0.00	0.00	QC 4 - 28		DAS 40 9-89
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
							QC 4 - 68		
130	Packaging 3-1 - Stock - B4B	1 pcs	5/17/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 28 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



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Container No: S178568



Part: RBW6305G19731-3G

Job No: 194237

Serial No/Batch: S178568

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 05/07/19

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				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	5/17/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

21
MAY 23 2019

RBW6305G19731-3G-27
RBW6305G19731-3G-29
RBW6305G19731-3G-25

Part Op 100 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19731-3G-27 and RBW6305G19731-3G-29 to RBW6305G19731-3G-25 foam. 6-Glue foam to case and pack case as per DWG.

110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1610-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6305G19731-3G-27 and RBW6305G19731-3G-29 to RBW6305G19731-3G-25 foam. 6-Glue foam to case and pack case as per DWG.

120 - (QC4- 100% Inspect kits for completeness)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1610-E	Case	1 Ea (1 ea)	100-Small Fab - 1	S060678 007
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	S145165 SF
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S021040
RBW6305G14631-3G	Tail Rotor Drive Quill Seal Housing Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S065045 96
RBW6305G14831-3G	Tail Rotor Drive Quill Lip Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S067423 84
RBW6305G15731-3G	Tail Rotor Drive Quill Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S067421 85
RBW6305G16031-3G	Drive Quill Seal Housing Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S065078 87
RBW6305G16231-3G	Fan/Ecs Drive Quill Lip Seal Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S067082 85
RBW6305G16831-3G	Fan Drive Quill Lip Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S061201 92
RBW6305G18331-3G	Ecs Drill Quill Lip Seal Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S065081 96
RBW6305G18631-3G	Ecs Drive Quill Housing Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S065494 89
RBW6305G19151-3G	Guide Fan Drive Quill Seal Housing Installer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S061407 103
RBW6305G19231-3G	Puller Rotor Brake Adapter Flange Remover	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S065502 05
RBW6305G19731-3G-23	Bottom Foam	1 Ea (1 ea)	110-Small Fab - 2 - B4B	S116634 S060680 007
RBW6305G19731-3G-25	Top Foam	1 Ea (1 ea)	110-Small Fab - 2 - B4B	S060682
RBW6305G19731-3G-27	Inside Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S061439 158
RBW6305G19731-3G-29	Tool Layout Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	S061453 158

Job Allocations

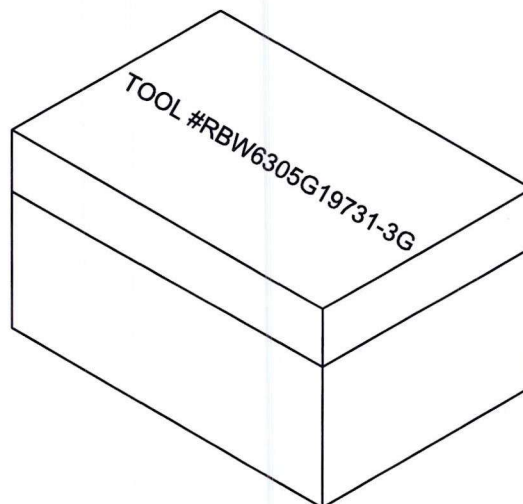
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1610-E	1	7	0
110-Small Fab - 2 - B4B	97524A032	4	317	0
	RB41011	1	341	0
	RBW6305G14631-3G	1	2	0
	RBW6305G14831-3G	1	2	0
	RBW6305G15731-3G	1	2	0
	RBW6305G16031-3G	1	5	0
	RBW6305G16231-3G	1	2	0
	RBW6305G16831-3G	1	2	0
	RBW6305G18331-3G	1	2	0
	RBW6305G18631-3G	1	5	0
	RBW6305G19151-3G	1	2	0
	RBW6305G19231-3G	1	2	0
	RBW6305G19731-3G-23	1	2	0
	RBW6305G19731-3G-25	1	1	0
	RBW6305G19731-3G-27	1	1	0
	RBW6305G19731-3G-29	1	1	0

Part Specifications

Specifications could not be found.

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CH'D -1, -17, -19, -21, -25, -27 BOM INFO. ADDED -29 PER R.W. CH'D -23 FOAM DIM'S, CH'D Ø4.02 DEPTH FROM 2.50 PER R.W. CH'D -25 FOAM DIM'S, CH'D CUTOUT TO RECESS FOR -27 & -29 PER R.W. ADDED TOOL NUMBER & ITEM NUMBER COLUMN -27 PER R.W.	3/24/11	RJC	RW
1A	CH'D -23 Ø4.02 HOLE DEPTH FROM Ø3.50 & CORRECTED SIDE VIEW PER D.W. CH'D Ø3.84 HOLE DEPTH FROM 7.75 & Ø4.69 HOL DEPTH FROM 3.00 TO FIT BETTER.	9/16/11	RJC	DW
1B	CH'D TITLE WAS "MAIN ROTOR DRIVE SEAL REPLACEMENT TOOL KIT" IS "MAIN ROTOR DRIVE TOOL KIT 2". CH'D -1 THRU -19 BOM DESCRIPTION TO MATCH PARTS MANUAL. -27 CH'D TOOL No. -27 & -29 CH'D FROM B/O TO MANUFACTURED.	10/31/13	CFS	RJC
1C	ADDED -33 & -35 TO BOM. -27 CH'D ITEM NUMBERS WAS 9-18 IS 1-10.	5/30/14	DPD	RJC

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 194237 MJS

19-0429

NOTE:

1. ALSO SOLD WITH KIT RBW6305G01531-3G, BOX TWO OF TWO.

RED BARN MACHINE

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	GUIDE, FAN DRIVE QUILL SEAL HOUSING INSTALLER		RBW6305G19151-3G	2
			-3	1	TOOL, FAN/ECS DRIVE QUILL LIP SEAL INSTALLER		RBW6305G16231-3G	2
			-5	1	PULLER, ROTOR BRAKE ADAPTER FLANGE REMOVER		RBW6305G19231-3G	2
			-7	1	TOOL, ECS DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G18631-3G	2
			-9	1	TOOL, ECS DRIVE QUILL LIP SEAL REMOVER		RBW6305G18331-3G	2
			-11	1	TOOL, DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G16031-3G	2
			-13	1	TOOL, T/R DRIVE QUILL LIP SEAL REMOVER		RBW6305G14831-3G	2
			-15	1	TOOL, T/R DRIVE QUILL SEAL HOUSING REMOVER		RBW6305G14631-3G	2
			-17	1	TOOL, T/R DRIVE QUILL LIP SEAL INSTALLER		RBW6305G15731-3G	2
			-19	1	TOOL, FAN DRIVE QUILL LIP SEAL REMOVER		RBW6305G16831-3G	2
		B/O	-21	1	CASE	PLASTIC	22 x 17 x 9-3/4 PELICAN #APP-1610-E	N/S
		B/O	-23	1	BOTTOM FOAM	Y20 BLACK	8.43 x 17.12 x 22.21 I.R. SPECIALTY FOAM	3
		B/O	-25	1	TOP FOAM	C200 FLAT BLACK	2.04 x 17.12 x 22.21 I.R. SPECIALTY FOAM	4
			-27	1	INSIDE PLACARD	PLASTIC	1/16 x 6-1/2 x 6-3/4	5
			-29	1	TOOL LAYOUT PLACARD	PLASTIC	1/16 x 6-1/2 x 8-3/4	6
		B/O	-31	1	RB PLACARD	ALUMINUM	RB41009 PLACARD	N/S
		B/O	-33	4	RIVET	ALUMINUM	Ø1/8 X 3/8 MCMMASTER-CARR #97447A130	N/S
		B/O	-35	4	WASHER	ALUMINUM	Ø1/8 MCMMASTER-CARR #90183A213	N/S

TITLE MAIN ROTOR DRIVE TOOL KIT 2		REV 1C
DWG NO. RBW6305G19731-3G		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED: D Weil HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		USED ON MODEL AW139
SCALE 1:16	DATE 2-7-11	SHEET 1 of 6

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					